

Work Order ID 67289

Tuesday, March 15, 2011 8:13:28 AM



Page 1

Item ID: D2563

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Weldment Assembly

Start Date: 3/15/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 3/21/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

M

Date: 11-03-15 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2563	Rev C

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2244 to 89.70" at 34 deg as per dwg D2563

2-Deburr ends

3-Weld (1 END CAP, LUG PLATES & MOUNTING ANGLE) as per dwg D2563 using DT 8343

4- Grind

11.04.12

4

Ø

110

QC9- Inspct visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

11.04.12

11.04.12

4

Ø

BB 11/04/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

4 11 04 13

130

Chemical Conversion Coat per QS1005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

4 6 11 10-18

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

4 BR 4-4-18

W/O:		WORK ORDER CHANGES					
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Start Date:	3/15/2011	Start Qty:	4.00		Cust Item ID:	
Required Date:	3/21/2011	Req'd Qty:	4.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 Large Fab	Weld per dwg A/R Aluminum rod Batch: <i>M114703</i> Large Fab	0.00							
	Memo	0.00							
	1-Inspect for foreign object per QSI 024								
	2-Weld Remainig End cap as per Dwg D2563 using DT 8343								
	3-Grind								
160 QC Quality Control	QC5 Inspect visual per QSI004- Fusion Welds <i>QC10</i>	0.00							
	Memo	0.00							<i>Pro →</i>
170 QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00							
	Memo	0.00							<i>Subalzo</i>

W/O: 67289		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/04/20	#160	Perm. Change change step to QC 10	<i>[Signature]</i>	11.04.20			S 11/04/20

Part No: D2563 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item Name: Step Weldment Assembly

Start Date: 3/15/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 3/21/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
175	Pressure Wash per QSI005 4.3	0.00							
	HandFinish	Memo							
	Hand Finishing	Touch up Alodine as per QSI005							
180	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
	Powdercoat	Memo							
	Powder Coating	Touch up Alodine then Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3							
		START TIME: 1:30 OVEN TEMPERATURE: 320° FINISH TIME: 2:00							
190	Wing Walk as per dwg QSI005 4.4 Batch 11173045	0.00							
	HandFinish	Memo							
	Hand Finishing								

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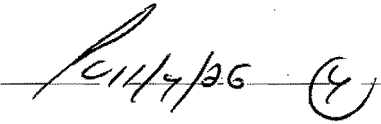

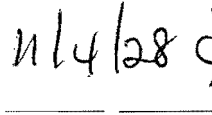
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Item ID: D2563 Accept  Setup Start 
Revision ID:
Item Name: Step Weldment Assembly Stop 
Start Date: 3/15/2011 Start Qty: 4.00  Cust Item ID:
Required Date: 3/21/2011 Req'd Qty: 4.00  Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							
210  Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo PPP 67291	0.00 0.00							
220  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							 MF 11-04-28

W/O:		WORK ORDER CHANGES					
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RESEARCH DESIGN AND METHODS

Required Qty: 4.00

Comments: IPP Rev:G 02.07.31 Re-format Location RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2244-116  Step Extrusion		Manufactured	No			100	Each	104.0000	1	4		11.04.05	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				104					
				57850				27					
				60307				77					
D2561  Lug		Manufactured	No			100	Each	31.0000	2	8		11.04.11	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA015				31					
				60096				7					
				66813				24					
D2564  Mounting Angle		Manufactured	No			100	Each	17.0000	2	8		11.04.11	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA018				17					
				62951				17					
D2673-34  End Plate		Manufactured	No			100	Each	144.0000	1	4		11.04.11	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA015				144					
				57527				1					
				59690				143					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 67289



Parent Item: D2563



Parent Item Name: Step Weldment Assembly

Start Date: 3/15/2011

Required Date: 3/21/2011

Start Qty: 4.00

Required Qty: 4.00

D2673-34

Manufactured No

150

Each

144.0000

1

4



End Plate

11.04.19

Location

Loc Qty

Loc Code

WA015

144

57527

1

59690

143

4

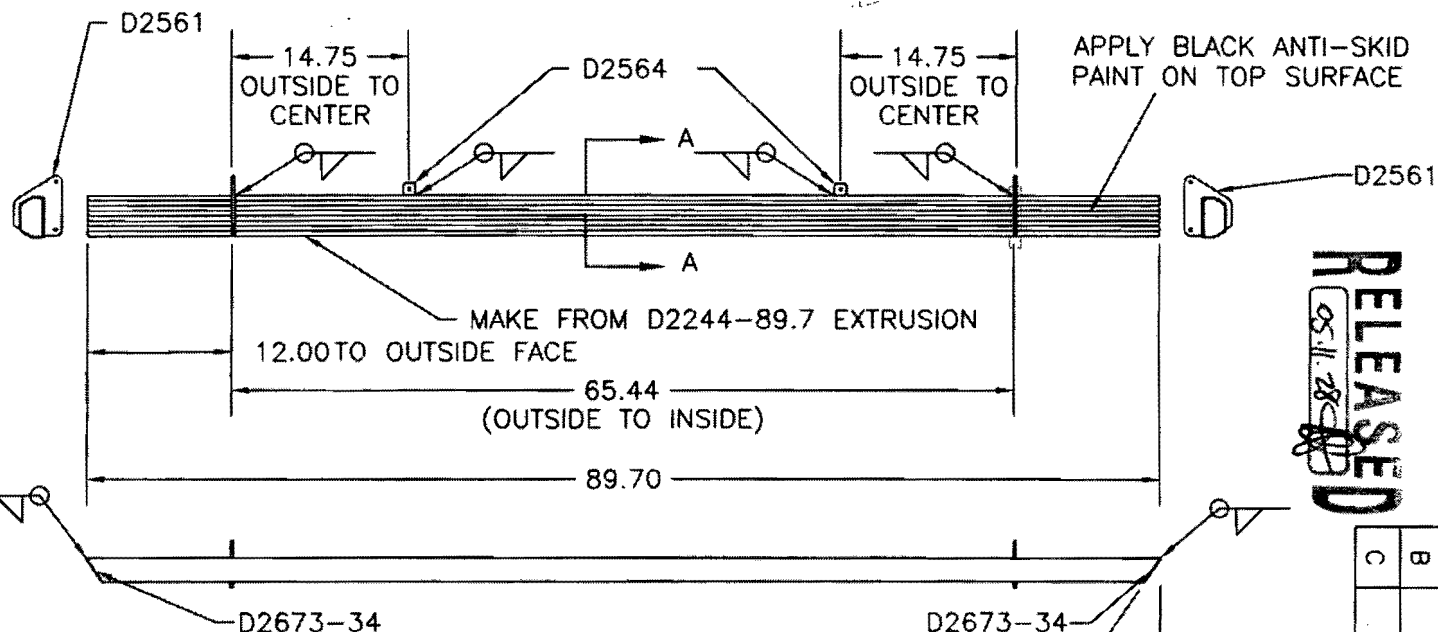
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D2563 STEP WELDMENT ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	MOUNTING ANGLE	2

*cut per drawing

D2563 STEP WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
05.11.28

DART COPY
N TO
ERING
CONTROLLED COPY
SUBJ AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 67289
2011-03-15

DESIGN	DRAWN BY	TITLE	REV. C
BW	44	D2563	SHEET 1 OF 1
CHECKED	APPROVED	D2563	SCALE
DATE	DATE	STEP WELDMENT ASSEMBLY	1:15
05.11.14	96.04.26	NEW ISSUE	
B	97.05.14	END CAPS CHANGED (WAS D2248)	
C	05.11.14	UPDATE NOTES	

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

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